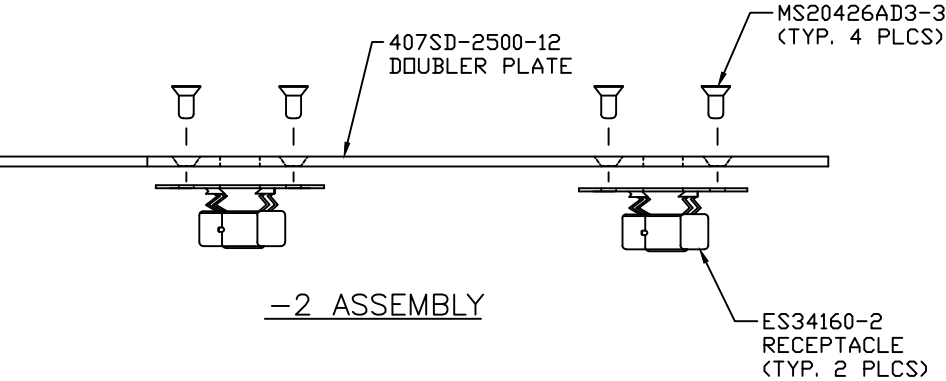
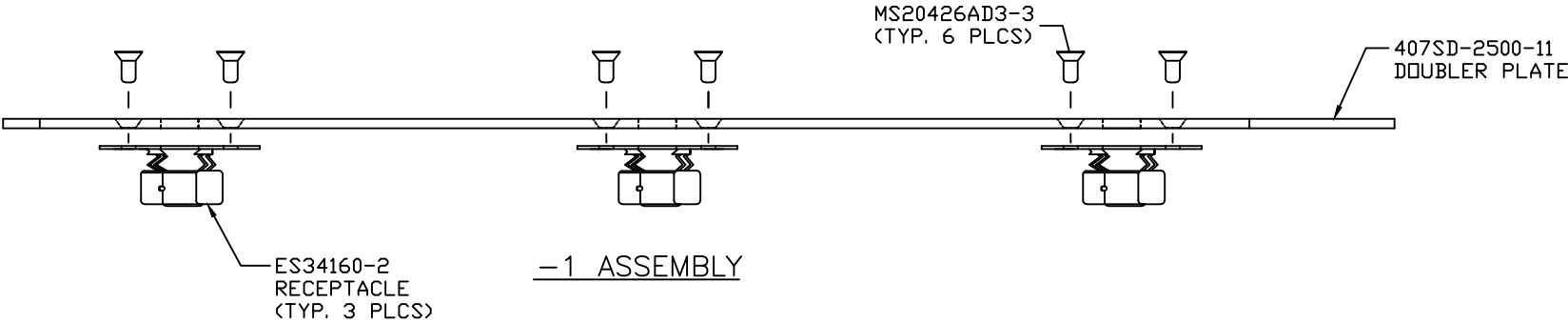


SHEET	REV	ECO	DATE	DESCRIPTION	BY	CHK	APR
1-4	A		02/26/01	REDIMENSIONED -11, -12, & -13 PARTS	MR	LS	MR
1	B		10/17/06	BOM CORRECTED: SHOWED -11 IN -3, -13 IN -1, SHOWED R35 QTY 1 IN -1, QTY 3 IN -3, MS20426AD3-3 QTY 2 IN -1, QTY 6 IN -3.	REB	LS	REB
1-4		1	04/09/08	ADDED W X L TO STOCKS, (X,Y) COORD'S & NOTE 1. ADDED (REF) TO HOLE ANGLES. REMOVED INNER & OUTER RADII. OVERALL LENGTHS WERE REF'D. -11: 8.84 WAS 9.37, 78° WAS 86°.	REB	LS	REB
1-8	C		09/25/13	ADDED -14, -15 & -16 PARTS. ADDED -4, -5 & -6 ASSY.	JJT	LS	JJT
7	D		01/06/14	CHANGED LAYOUT OF -15 FOR EASE OF INSPECTION. MODIFIED MIDDLE HOLE LOCATION OF -15, WAS 4.227, 0.638. ROTATED RECEPTABLE HOLES ON RIGHT, WAS 16 DEGREES.	JJT	LS	JJT
8	E		12/18/15	SHT. 7 -15 REMOVED .467 DIM & ADDED .884-.854 DIM, SHT. 8 -16 REMOVED '1.55 X 7.60' FROM STOCK NOTES.	JT	LS	JT
3-8	F		05/30/19	ADDED DETAIL A TO SHTS 3-8; ADDED DETAIL B TO SHT 6	DT	LS	ZA
1-2,6-8	G		05/11/21	R35 NOW ES34160-2. SHT 2: ADDED P/N CALLOUTS; SHT 6-8: ADDED DIMENSIONS TO UNDEFINED FEATURES;	DT	LS	ZA



		2				NAS1399C3-3	RIVET (ALT. CR2662-3-03)
		2				NAS1149FN232P	WASHER
		1				ES34160-1	RECEPTACLE
4	3	2	1	2	3	ES34160-2	RECEPTACLE (ALT. R35 (CLASS B))
8	6	4				MS20427M3-3	RIVET (ALT. MS20426T3-3)
			2	4	6	MS20426AD3-3	RIVET
					1	407SD-2500-11	DOUBLER PLATE
				1		407SD-2500-12	DOUBLER PLATE
			1			407SD-2500-13	DOUBLER PLATE
		1				407SD-2500-14	DOUBLER PLATE
						407SD-2500-15	DOUBLER PLATE
1						407SD-2500-16	DOUBLER PLATE
-6	-5	-4	-3	-2	-1		
ASSY	ASSY	ASSY	ASSY	ASSY	ASSY	PART NUMBER	DESCRIPTION
QTY	QTY	QTY	QTY	QTY	QTY		

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PROTO

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Paravion® Inc.  
Technology

DIMENSIONS IN INCHES  
TOLERANCES EXCEPT WHERE NOTED:

.X = ± .1  
.XX = ± .05  
.XXX = ± .010  
ANGLES = ± 1°

THREADS:  
INTERNAL=CLASS 2B  
EXTERNAL=CLASS 2A

TITLE DOUBLER ASSEMBLY  
DRAWING NO. 407SD-2500

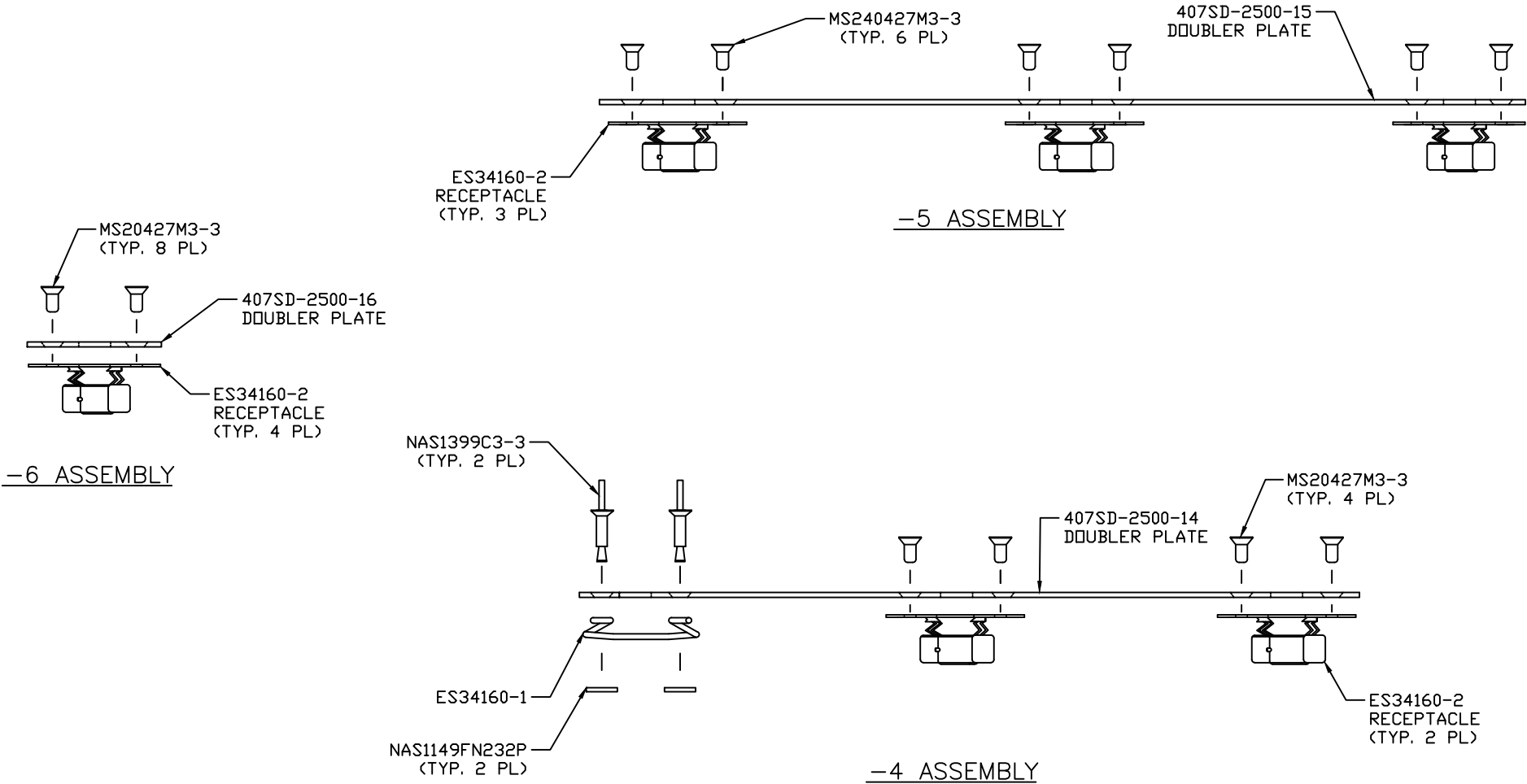
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SHEET 1 OF 8

BREAK ALL SHARP EDGES



BREAK ALL SHARP EDGES

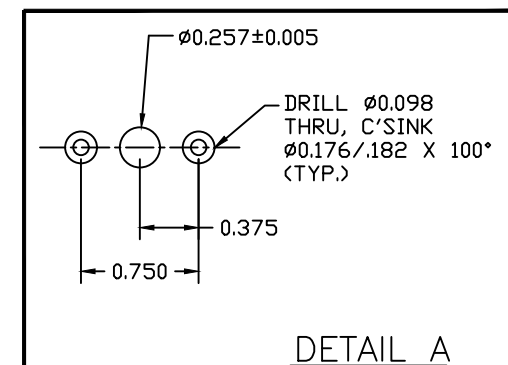
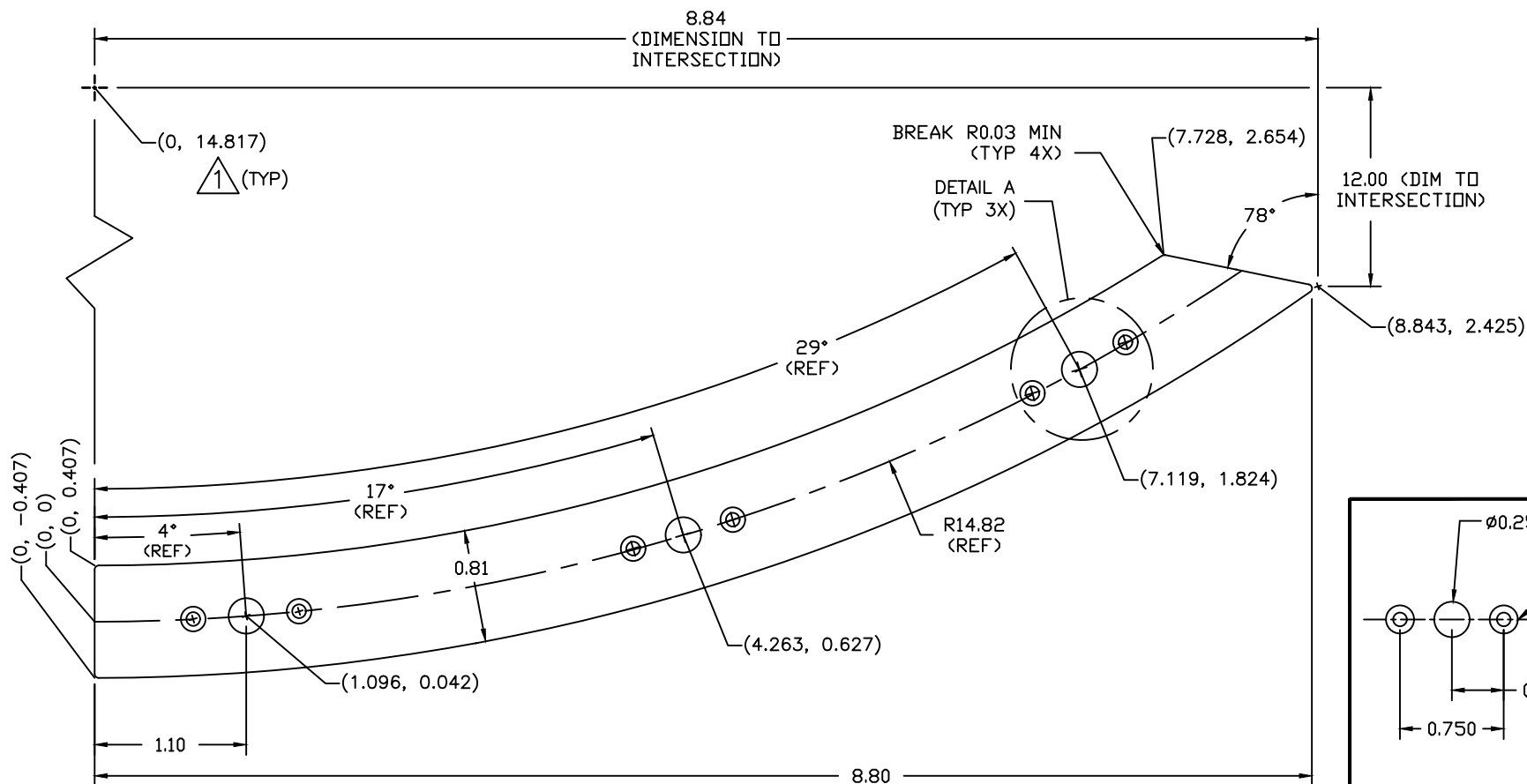
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MATERIAL: 6061-T6 AL, PER QQ-A-250/11 OR AMS 4027  
 STOCK: 0.063 SHEET, 1.55 X 9.95  
 FINISH: BLACK ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK  
 SURFACE FINISH  $\sqrt{125}$

1  $\Delta$  COORDINATE POINTS (REF) FOR MACHINE SET-UP.



-11 DOUBLER PLATE

BREAK ALL SHARP EDGES

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PROTO

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DIMENSIONS IN INCHES		DRAWN BY		APRVD. BY	CHK'D BY	DATE	REV	ECO
TOLERANCES EXCEPT WHERE NOTED:		KRG		PR	LS	10/27/99	G	
.X = ± .1								
.XX = ± .05								
.XXX = ± .010								
ANGLES = ± 1°								
THREADS:		DO NOT SCALE DRAWING						
INTERNAL=CLASS 2B		SHEET						
EXTERNAL=CLASS 2A		3 OF 8						
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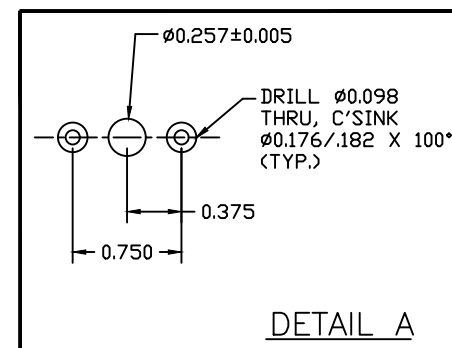
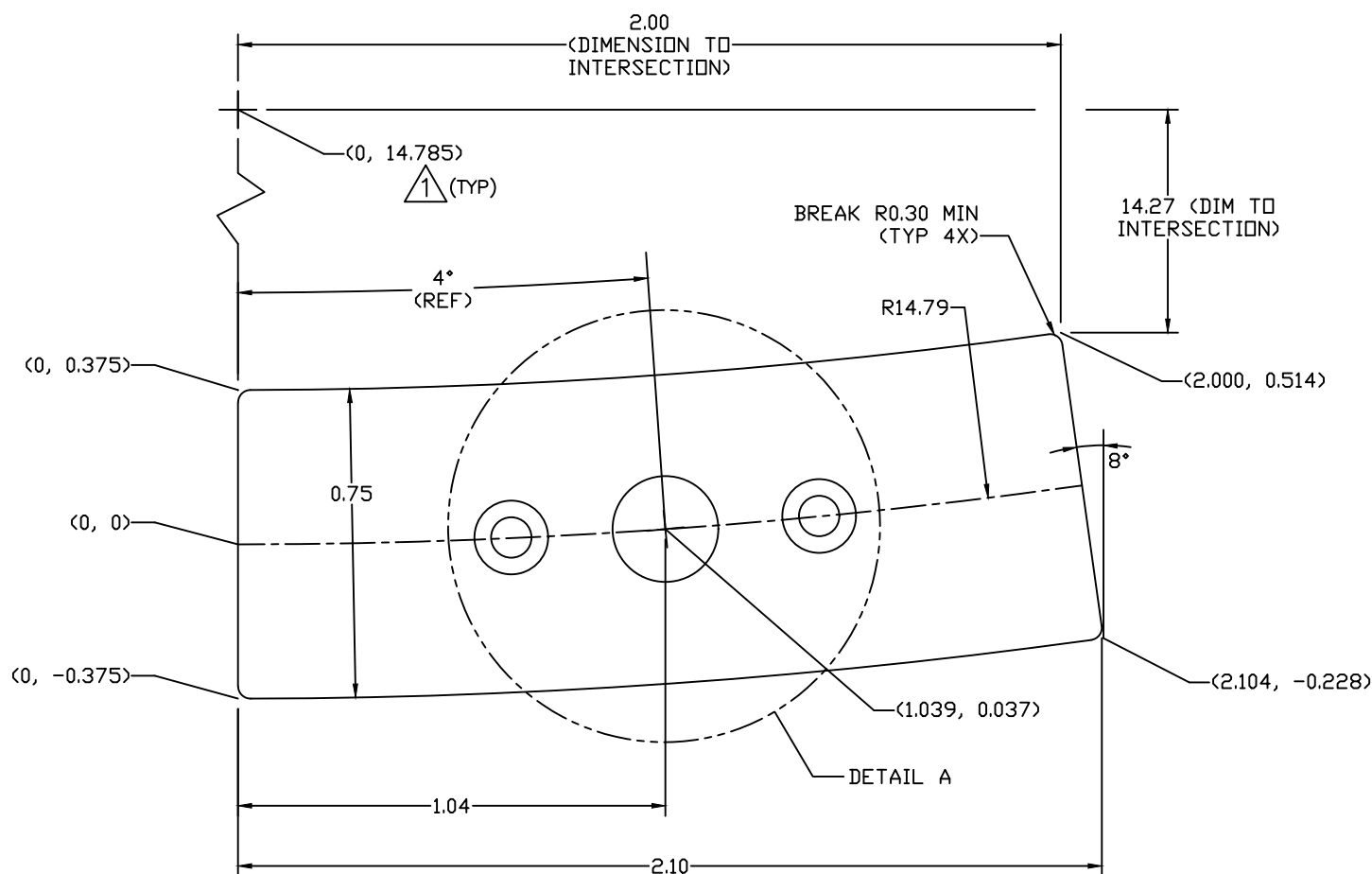
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<div>Paravion® ✓ Technology Inc.</div> <div>DIMENSIONS IN INCHES</div> <div>TOLERANCES EXCEPT WHERE NOTED:</div> <div>.X     = ± .1</div> <div>.XX    = ± .05</div> <div>.XXX   = ± .010</div> <div>ANGLES = ± 1°</div> <div>THREATS:</div> <div>INTERNAL=CLASS 2B</div> <div>EXTERNAL=CLASS 2A</div>	TITLE DOUBLER ASSEMBLY				DRAWING NO. 407SD-2500	
	DRAWN BY	APRVD. BY	CHK'D BY	DATE	REV	ECO
	KRG	PR	LS	10/27/99	G	
	DO NOT SCALE DRAWING				SHEET	
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4 □ 8						

MATERIAL: 6061-T6 AL, PER QQ-A-250/11 OR AMS 4027

STOCK: 0.063 SHEET, 0.90 X 2.21

FINISH: BLACK ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK

SURFACE FINISH  $\sqrt{125}$ -13 DOUBLER PLATE

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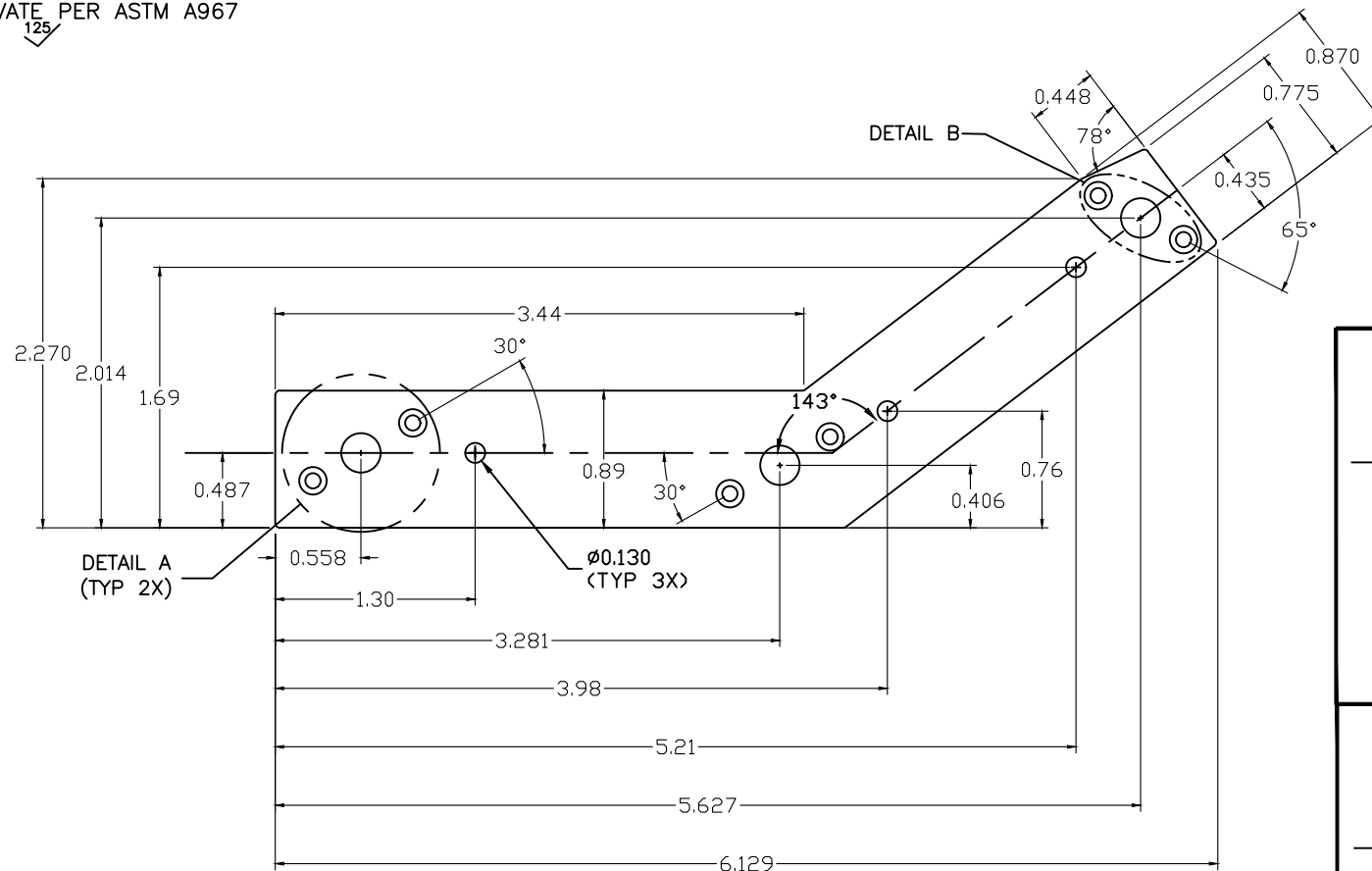
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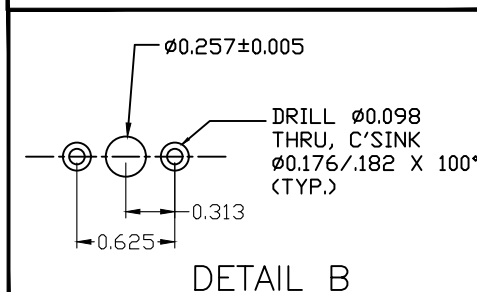
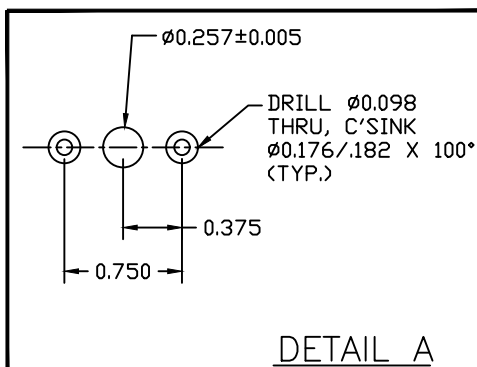
Paravion® Technology Inc.	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:	
.X	= ± .1
.XX	= ± .05
.XXX	= ± .010
ANGLES	= ± 1°
THREADS:	
INTERNAL=CLASS 2B	
EXTERNAL=CLASS 2A	

TITLE DOUBLER ASSEMBLY				DRAWING NO. 407SD-2500		
DRAWN BY	APRVD. BY	CHK'D BY	DATE	REV	ECO	
KRG	PR	LS	10/27/99	G		
DO NOT SCALE DRAWING				SHEET		
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MATERIAL: 304 STAINLESS STEEL PER AMS 5513; ALT AISI 316 SS PER AMS 5524  
 STOCK: 0.040 SHEET, 2.40 X 7.50  
 FINISH: PASSIVATE PER ASTM A967  
 SURFACE FINISH  $\sqrt{125}$



## -14 DOUBLER PLATE



BREAK ALL SHARP EDGES

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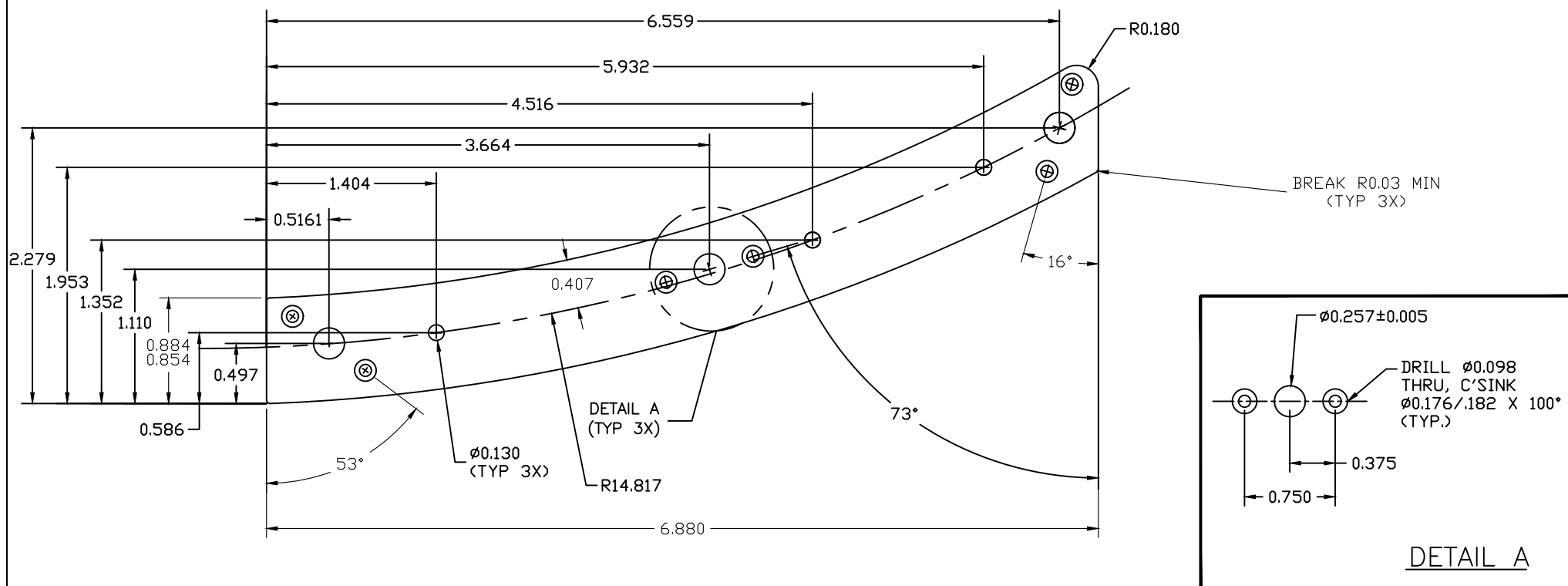
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.X = ± .1		KRG	PR	LS	10/27/99
.XX = ± .05					
.XXX = ± .010					
ANGLES = ± 1°					
THREADS:					
INTERNAL=CLASS 2B					
EXTERNAL=CLASS 2A					
		DO NOT SCALE DRAWING			
		SHEET			
		6 OF 8			

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MATERIAL: 304 STAINLESS STEEL PER AMS 5513; ALT AISI 316 SS PER AMS 5524  
 STOCK: 0.040 SHEET, 3.30 X 9.10  
 FINISH: PASSIVATE PER ASTM A967  
 SURFACE FINISH  $\sqrt{125}$



-15 DOUBLER PLATE

BREAK ALL SHARP EDGES

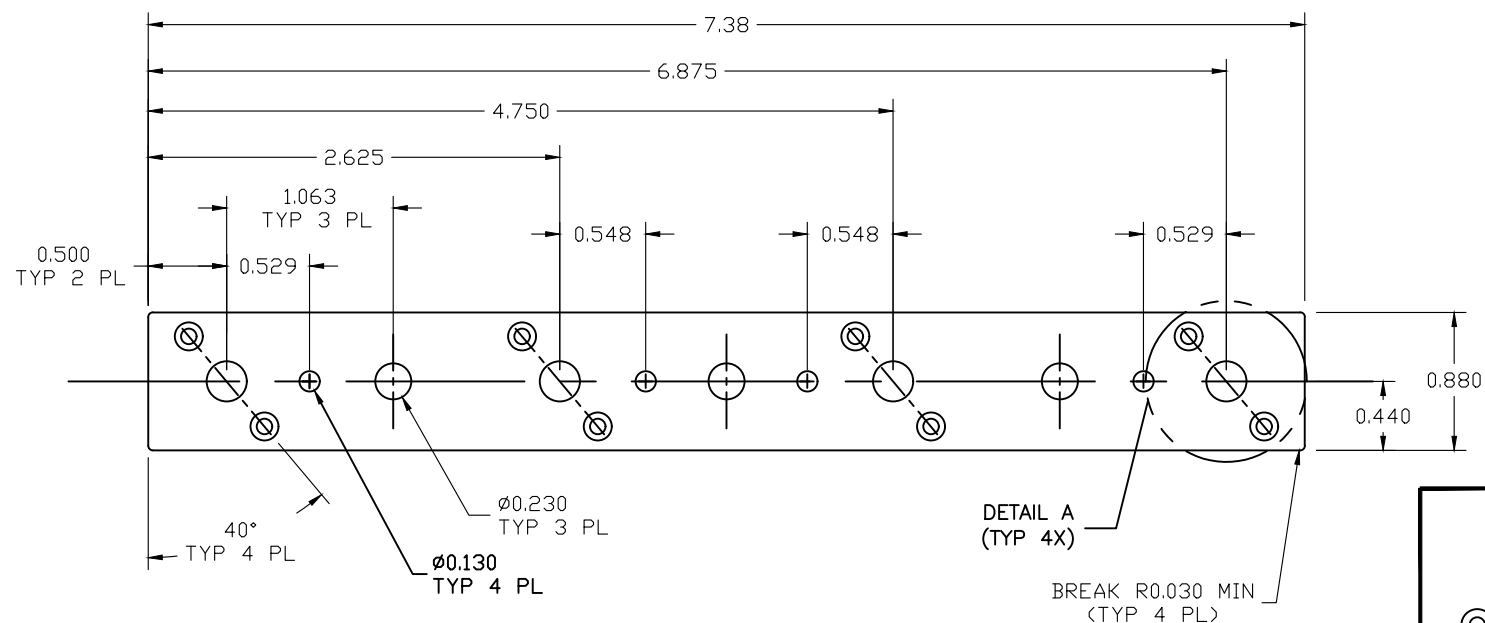
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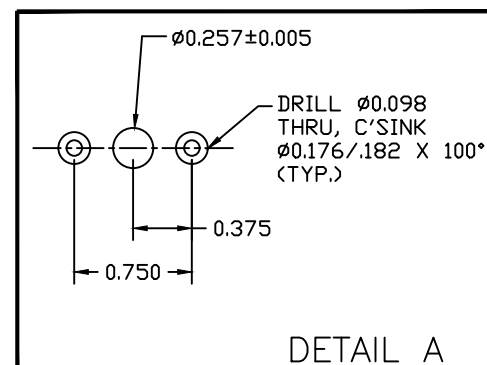
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.XX = ± .05		DO NOT SCALE DRAWING			REV G
.XXX = ± .010		SHEET			ECO
ANGLES = ± 1°		7 OF 8			
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INTERNAL=CLASS 2B					
EXTERNAL=CLASS 2A					

MATERIAL: 304 STAINLESS STEEL PER AMS 5513; ALT AISI 316 SS PER AMS 5524  
 STOCK: 0.040 SHEET  
 FINISH: PASSIVATE PER ASTM A967  
 SURFACE FINISH  $\sqrt{125}$



-16 DOUBLER PLATE



DETAIL A

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TOLERANCES EXCEPT WHERE NOTED:		KRG		PR	LS	10/27/99
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.XXX = ± .010						
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